

Date: Wednesday, 13/08/2008 10:55:13 AM  
 User: Julie Lecocq

*split 08-09-08*  
**Process Sheet**

Customer : CC-DAR01 Dart Aerospace Ltd.  
 Job Number : 41207-~~4~~-3  
 Estimate Number : 13291

Drawing Name : GLARESHIELD ASSEMBLY

P.O. Number :  
 This Issue : 13/08/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : 1/1 Type : SMALL/MED FAB  
 Previous Run : 41018

Part Number : D3690041  
 Drawing Number : D3690 REV B  
 Project Number :  
 Drawing Revision : B  
 Material :  
 Due Date : 01/09/2008

Qty: *1* Um: *Each*

Written By :  
 Checked & Approved By : *JUL 08-8-13*  
 Comment : Est Rev:A 08-04-29 new issue DD verified by:ec  
 Est Rev:B 08-07-14 revB as per dwg DD verified by:ec

**Additional Product**

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
 Pick Packing Kit

2.0 D36901 Glareshield



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)  
 Glareshield  
 batch: *41222* *1/1021* *B 40664* *SB 08/09/08* *(3)*

3.0 D3697041 Tube Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)  
 Tube Assembly  
 batch: *40665* *(2)* *1/1021* *(2)* *FF 08/09/08* *(3)*

4.0 D36981 Support Angle

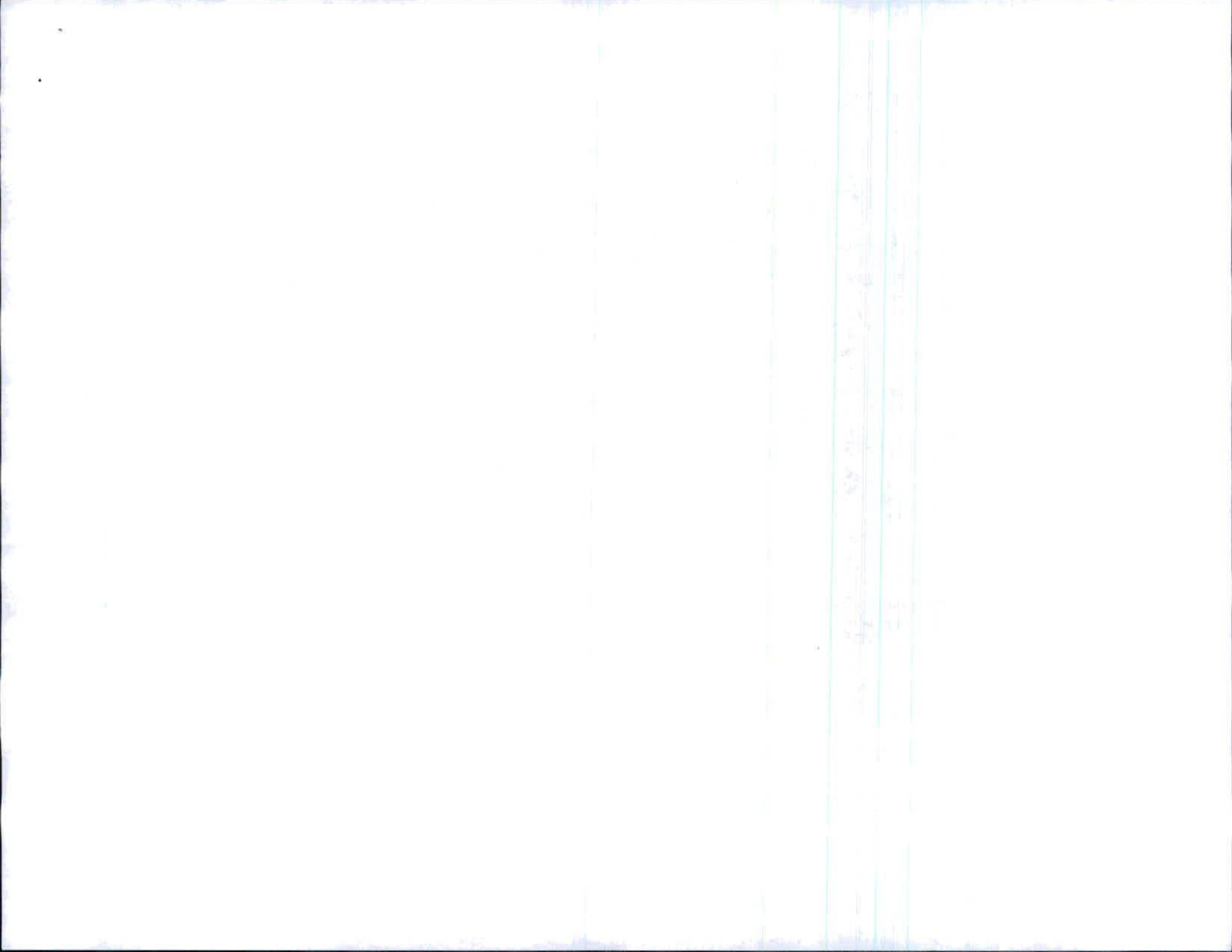


Comment: Qty.: 1.0000 Each(s)/Unit Total: ~~3.0000~~ Each(s)  
 Support Angle  
 batch: *341022* *B 41656* *SB 08/09/08* *(3)*

5.0 AN960JD3 Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total: ~~18.0000~~ Each(s)  
 Washer  
 batch: *1107989* *FF 08/09/08* *(3)*





Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3690-041 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>41207-3</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
080828	4.0	All D3698-1 B41022 & B40666 angles are scrap. 2 D3690-041's were drilled to try and install the D3698-1. R.C.: error on the angles was never noticed, and part was curving inside the 5.50" dimension, and parts were not (The D3698-1's) were not measured along, as they were drilled.	/as1012	Scrap & destroy the D3698-1 B41022, and pull from stock B40666 to scrap.	SB 08/08/29	08-09-03	/as1012	/as1012
		Lack of Attention.	/as1012	See NCR 08-080.	SB 08/08/29	08-09-03	/as1012	/as1012
08/09/05	8	Open hole at .129 and Prop Rivet for change CR 3213-4-03 Instead Rivet MS2070AD3-5	#	ACCEPTABLE PLANNED	08-09-05		/as1012	08-09-08

NOTE: Date & initial all entries





# Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: GLARESHIELD ASSEMBLY

Job Number: 41207

Part Number: D3690041

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

MS20426AD34

RIVET



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

RIVET

batch: M105970

FF

08/09/08

7.0

MS20476AD34

CR 3213-4-03

Rivet, Universal Head

08.09.05



(P10)

Comment: Qty.: 35.0000 Each(s)/Unit Total: 105.0000 Each(s)

Rivet, Universal Head

batch: M15541

M16896, 08.09.05

FF 08/09/08

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- transfer drill D3697-041 and D3698-1 in D3690-1 and assemble as per dwg D3690

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-09-08 (1)

08/09/08 (13)

(P12)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # and batch # using a fine point permanent marker on inside of part and Stock

Location:

08/09/08

sel

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/08

Job Completion



10.0 - Identify and stock

8/9/8

SE

(K)

08-09-08






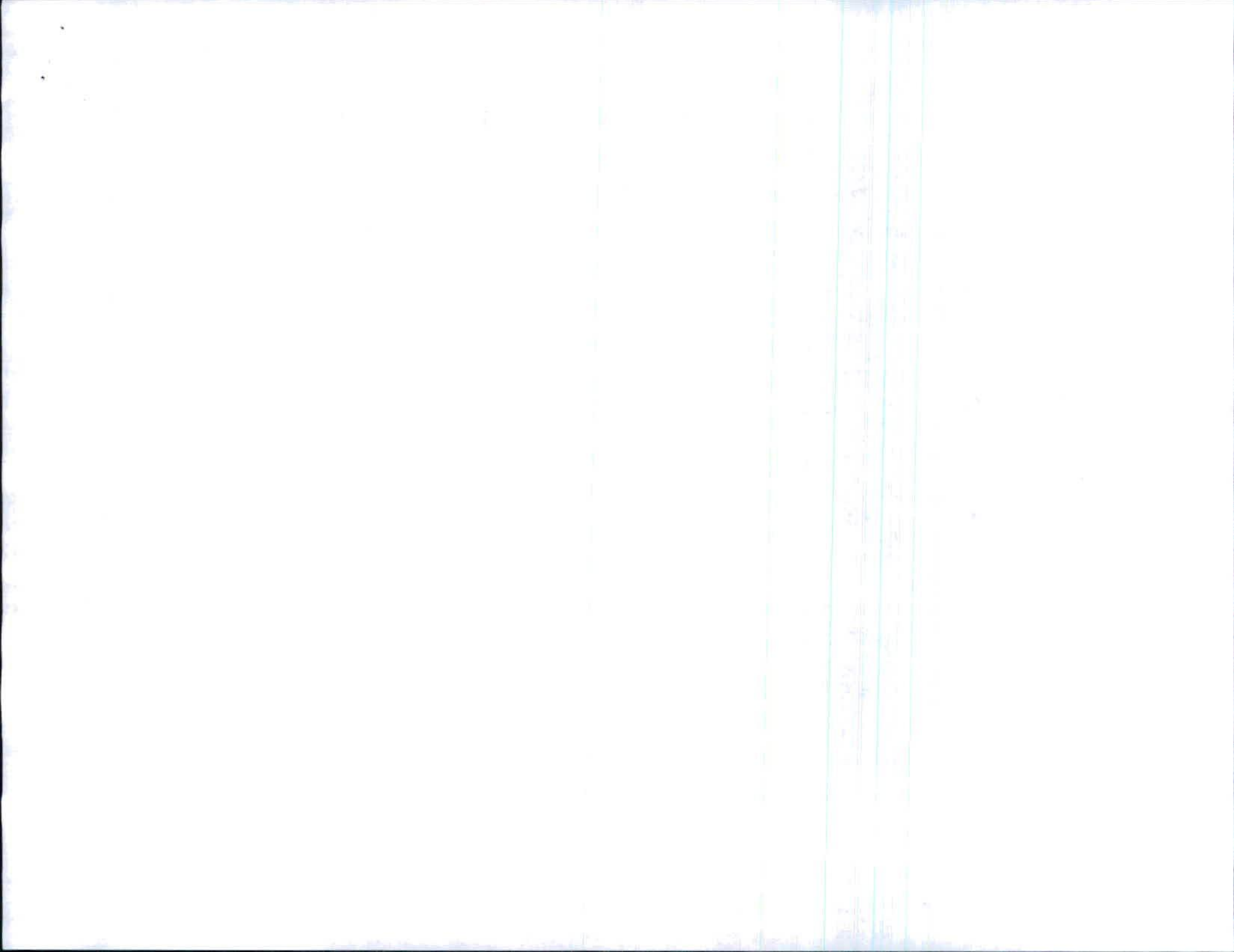
# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
<del>08/09/03</del>	<del>7.0</del>	<del>MS20470AD3-5 are required - 4's are too short perm change: update dng.</del>	<del>N/A</del>	<del></del>	<del></del>	<del></del>	<del></del>	
08/09/04	7.0	replace MS20470AD-34 for cherry rivet CER 274'SS3-Y perm - change & update dng				08-09-03	08-09-03	

Part No: D3690-041 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>41207-3</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.09.03	8.0	Hole MARKED  ON DWG WAS ENLARGED WHILE REMOVING RIVET. PER REWORK ON <del>W.O.C</del> ABOVE.	08.09.03	REPLACE MS20470AD3-5 WITH MS20470AD4-5 FOR M LUG 918 THIS W/O ONLY (QTY=1).			08.09.03	
08-09-06	8.0	1 Part, The original rivets are pressed into the glark shield upon ASS'y on the D3697-041. Also 1 hole is enlarge around the rivet. MS20470AD4-5 (above) R.C: Lack of Attention upon re-work	08/09/06	Remove: Replace carefully the D3697-041, <del>and</del> 1 x D3697-041 B 1 x D3697-041 scrap.			08/09/06	08-09-06
08-09-06	8.0	hole is enlarged around 1 x CER 274'SS3-4 rivet, & another was drilled and installed through the original MS20470AD3-5 rivet. R.C: Lack of Attention & carelessness	08/09/06	Remove & replace carefully the D3697-041 Qty 1 Pick a new one B			08/09/06	08-09-06

NOTE: Date & initial all entries





W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
skls	# 9.1	Permenet change SPRy Part AS per OST 005 4.2. FLAT BLACK using cyhaseurit 22. ml 08 09 08 ① 108186	MA	08/09/08		08-09-08	08/09/08	
skls	# 9.2	Respect SPRy Part QCI4 in	<del>MA</del>	<del>08/09/08</del> 08-09-08 ①		08-09-08	08/09/08	

Part No: D3690-041 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: 41207-3

## WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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